

## Finger joint cutter

### A16-280

Latest grinding technology for finger joint cutters.  
Best grinding time cycles, excellent surface and accurate clearance angle on the tooth flank.

### 1. Cycletime for production

#### Tool specifications

Diameter	160 mm				
No of cutting edges	4				
Length of cutting edges	33 mm				
Helix	0 deg				
Material	HSS				
	Probing	Roughing	Flute	Outer diameter	Finishing
Operations					
Feed [mm/Min]	2000	60	250	300	300
Power [kW]	2	12	2	1	1
Cutting feed [m/s]	-	32	32	32	32
Grinding wheels		5	3	2	6+6
Grinding time [s]	19	1380	270	225	840
Total cycle time	approx. 45 Min				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerable.

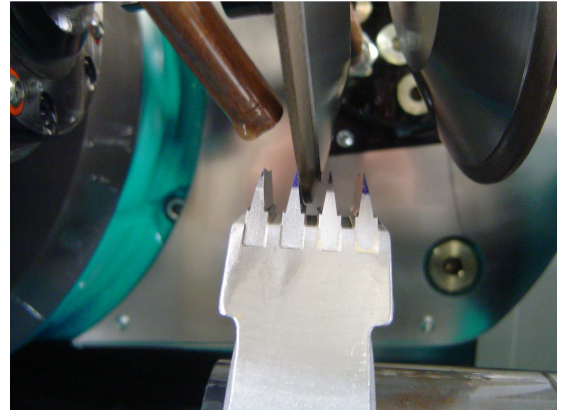
### 2. Used grinding wheels

- 2 Ø75B126 11V9
- 3 Ø125B126 12V9
- 5 Ø175B126 shaped wheel
- 6 Ø175B126 12V2

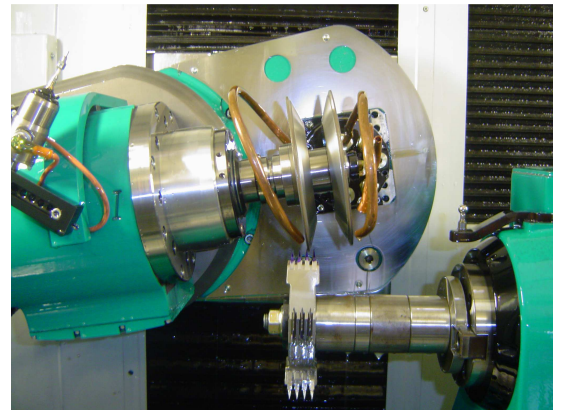
### 3. Machine and Software requirements

Machine: 5 axes CNC: GEMINI DMR  
Control : Fanuc 160i  
Coolant: Emulsion, pressure 6 – 7 bar  
Software: Quinto 4.2, dxQ

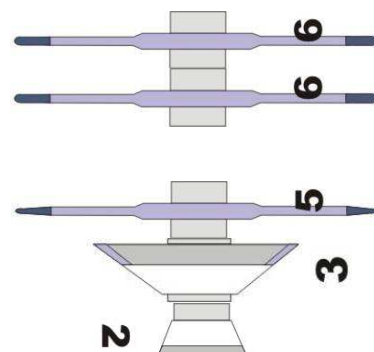
HM 7.5.07



Finger joint cutters are ground on diameter, face and tooth flank.



Finishing wheels with axial or concave shape



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